

Work Order ID 163252

Tuesday, June 27, 2017 10:01:12 AM

163252

Page 1

Item ID: D2484 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Locknut
 Start Date: 6/27/2017 Start Qty: 25.00 **30** JUN 27 2017 **DAS 13 9-89**
 Required Date: 7/11/2017 Req'd Qty: 25.00 ***25***
 Reference: ***25*** Cust Item ID:
 Customer:

Approvals: Process Plan: **DAS 21 9-89** Date: Tooling: Date: Run Start ***NR1***
 QC: Date: JUN 27 2017 SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2484	Rev A								

100 PURCHASING 0.00 **30** JUN 27 2017 **DAS 13 9-89**
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: **36835** Order per Dwg D2484 Material release note required
 McMaster p/n: 91343A100

110 Receive & Inspect for Damage & Mat'l Certs 0.00 **30x8pt7-7-3**
110
 Packaging Memo 0.50
 Packaging Ensure Material Release Note is attached

120 QC5- Inspect part completeness to step on W/O 0.00 **30** **DAS 38 9-89**
120
 QC Memo 0.50
 Quality Control

JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 163252

Tuesday, June 27, 2017 10:01:12 AM

163252

Page 2

Item ID: D2484

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Locknut

Start Date: 6/27/2017 Start Qty: 25.00

25

Cust Item ID:

Required Date: 7/11/2017 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: GA

0.00

130

Packaging

Memo

0.25

Packaging

30X

DAS
26
9-89

JUL 03 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

2.50

Quality Control

17/7/49



JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, June 27, 2017 10:01:15 AM

Page 1

Work Order ID: 163252

163252

Parent Item: D2484

D2484

Parent Item Name: Locknut

Start Date: 6/27/2017

Required Date: 7/11/2017

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP A00.03.02New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2484P *D2484P* Lock Nut		Purchased			No	110	Each	0.0000	1	25 30x 30			

**30 8/17-7-3.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. A
CHECKED BW	APPROVED 	D2484	SHEET 1 OF 1
DATE	TITLE		SCALE
95:10:06	LOCK NUT		

SPECIFICATION CONTROL DRAWING



1/4-20 LOW PROFILE
NYLON LOCK NUT



OR

1/4-20 SERATED FLANGE
LOCK NUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. 163250405

180623

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36835

Purchase Order Date 6/27/2017

PO Print Date 6/27/2017

Page Number 2 of 4

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Total: \$56.00

Deliver To: SYLVIE

4	D2484P	Lock Nut	6/29/2017 Yes 6/29/2017	30.00 Each	\$0.36	\$10.89
---	--------	----------	-------------------------------	---------------	--------	---------

AS PER DWG D2484 REV. A
B163252

Line Total: \$10.89

5	95606A170	Washer	6/29/2017 Yes 6/29/2017	100.00 Each	\$0.09	\$8.60
---	-----------	--------	-------------------------------	----------------	--------	--------

AS PER DWG D3631 REV. A
B163247

Line Total: \$8.60

6	53485K22	Hose Fitting	6/29/2017 Yes 6/29/2017	FN 10.00 Each	\$2.56	\$25.62
---	----------	--------------	-------------------------------	---------------------	--------	---------

AS PER DWG D5421 REV. B
B163245

Note:

6/27/2017



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Sylvie

Purchase Order
PO36835

Order Placed By
Chantal Lavoie

McMaster-Carr Number
5177594-03

Page 1 of 1

06/27/2017

Line	Product	Ordered	Shipped
2	6264K72 Adding-and-Connecting Link for ANSI Number 40-SS Single Strand Corrosion-Resistant Roller Chain	40 Each	40
3	29045A742 135 Degree Point Long-Life Drill Bit, Wire Gauge 20	20 Each	20
4	91343A106 316 Stainless Steel Serrated Flange Locknut, Super-Corrosion-Resistant, 1/4"-20 Thread Size, Packs of 10 Your Part Number: D2484P	3 Packs	3
5	95606A170 Nylon Plastic Washer for 7/16" Screw Size, 0 5" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1
6	53485K22 Push-on Brass Barbed Hose Fitting, 1/4" ID, 7/16"-20 UNF 37 & 45 Degree Female Flared End, Packs of 5, Sold 5 Per Pack	2 Packs	2
7	5155T28 Laboratory Tygon PVC Tubing for Chemicals, 1/4" ID, 1/2" OD, 10 Feet Long	100 Feet	20
8	50715K676 37 Degree Flared Fitting for Stainless Steel Tubing, Straight Adapter for 1/4" Tube OD, 7/16"-20 UNF Male	8 Each	8

Shipped separately from our New Jersey warehouse on 06/27

7	5155T28 Laboratory Tygon PVC Tubing for Chemicals, 1/4" ID, 1/2" OD, 10 Feet Long	100 Feet	80
---	--	-------------	----

DAS
38
9-89

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 36936353
Purchase Order: PO36835
Release:
McMaster-Carr Number: 5177594-03

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 27-Jun-2017
Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

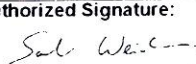
Forwarding Agent:

Billing
Attention:
Shipping
Attention: Sylvie

Contact:

Line	Description	Qty & Unit	Unit Price	Extension
2	6264K72 Adding-and-Connecting Link for ANSI Number 40-SS Single Strand Corrosion-Resistant Roller Chain Country of Origin: Japan Schedule B #: 731519 ECCN #: EAR99 NLR	40 EA	\$7.80	\$312.00
3	29045A742 135 Degree Point Long-Life Drill Bit, Wire Gauge 20 Country of Origin: United States Schedule B #: 820750 ECCN #: EAR99 NLR	20 EA	\$2.80	\$56.00
4	91343A100 316 Stainless Steel Serrated Flange Locknut, Super-Corrosion-Resistant, 1/4"-20 Thread Size, Packs of 10 D2484P Country of Origin: Taiwan Schedule B #: 731816 ECCN #: EAR99 NLR	3 PK	\$3.63	\$10.89
5	95606A170 Nylon Plastic Washer for 7/16" Screw Size, 0.5" ID, 0.688" OD, Off-White, Packs of 100 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$8.60	\$8.60

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

Shipping Weight (in kgs): 2	Number of Packages: 1	Invoice Amounts:	Merchandise Amount: \$549.67 Canadian GST/HST: \$73.18 Shipping Charges: \$13.22 Total (In USD): \$636.07
Package Dimensions: 14 X 21 X 34 CM = .010 CUBIC M		Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days	
Authorized Signature: 		Remit payment to: (by wire transfer) Bank of America 222 Broadway New York, NY 10038 Account 86666-02021 SWIFT BOFAUS3N	
Date: 27-Jun-2017		(by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA	
Name: Sarah Weinberg	Title: Operations Mgr.	Page 1 of 2	

McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 36936353
 Purchase Order: PO36835
 Release:
 McMaster-Carr Number: 5177594-03

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
6	53485K22 Push-on Brass Barbed Hose Fitting, 1/4" ID, 7/16"-20 UNF 37 & 45 Degree Female Flared End, Packs of 5, Sold 5 Per Pack Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	2 PK	\$12.81	\$25.62
7	5155T28 Laboratory Tygon PVC Tubing for Chemicals, 1/4" ID, 1/2" OD, 10 Feet Long Country of Origin: United States Schedule B #: 391732 ECCN #: EAR99 NLR	20 FT	\$3.52	\$70.40
8	50715K676 37 Degree Flared Fitting for Stainless Steel Tubing, Straight Adapter for 1/4" Tube OD, 7/16"-20 UNF Male Country of Origin: United States Schedule B #: 730729 ECCN #: 2B999 NLR	8 EA	\$8.27	\$66.16
	NOTE These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. government or as otherwise authorized by U.S. law and regulations.			
	NOTE Tracking number(s) for this shipment: CPK005564449			

817-73